

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023863**Date Inspected:** 20-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

ZPMC performing personnel performing Heat Straightening on weld jt no: Seg3020B-029 and 042 (Floor Beam to Anchorage Plate, complete joint penetration (CJP) weld at Panel Point (PP) 128.7). Heat Straightening was done as per Heat Straightening Report (HSR) 10376. ZPMC Quality Control (QC) was identified as Zhu Lin. See attached photo for details.

OBG Seg 13AE and Seg 13BE:

ABF personnel performing Ultrasonic Testing (UT) of weld jt no: OBE13B-001, 002 and 003 [Deck Panel (DP) to DP, CJP splice weld]. See attached photo for details.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG Seg 13AW and Seg 13BW:

ABF personnel performing Magnetic particle testing (MT) after removal of temporary attachments at weld jt no: OBW13-001 (DP to DP, CJP splice weld). See attached photo for details.

OBG Seg 13BW:

ZPMC personnel performing fit-up of Splice Plate X3883A with Architectural Housing (AH) 3002A and web plate X4498C at PP122. See attached photo for details.

OBG Seg 13AW:

Repair welding of weld joint no: Seg3013R-221 (Floor Beam to Longitudinal Diaphragm CJP weld). The welder is identified as 067947 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): 20828 Rev-0.

OBG Seg 13CW:

The SMAW process on weld joint no: Seg 3015A-012 (Bottom Panel to Side Panel CJP, hold-back weld]. The welder is identified as 057220 and was observed welding in 4G position. ZPMC QC was identified as Shi Li. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer